Work Order ID 93354 Page 1 November-19-12 8:58:04 AM 647.2511 Accept *N900040100* Setup Start Item ID: Revision ID: Stop Nut Item Name: **Start Date:** 11/15/12 **Start Qty: 12.00 Cust Item ID:** Req'd Qty: 12.00 Required Date: 12/07/12 **Customer:** Reference: Run Start Process Plan: MLJ Date: 12-11-19 Tooling: Approvals: Date: Stop QC: Date: SPC (Y/N): Date: Tool ID Reject Reject Tool # Plan Accept Insp. Sequence ID/ **Operation** Set Up/ Qty Code **Qty** Number Stamp Work Center ID Description **Run Hours** Draw Nbr **Revision Nbr** N/C 647.2500 0.00 100 13.3.24 3 DOOSAN LATHE *100* 0.00 Doosan Memo 1- Turn as per Forio FB144 AND DWG Doosan Lathe DWG Rev: M/C FOLIO Rev: -Deburr per dwg 13.3.24 3 A QC2- Inspect parts off machine FAI/FAIB 0.00 110

0.00

Memo

QC

Quality Control

٨.

										DQA:	Date	•
NCR:	Yes /	No				WORK ORDER NON-C	CONFOR	MANCE / UPD	ATE	OA Classel	Data	
						ſ	<u> </u>			QA Closed:	Date	
Work Ord	er.					DISPOSITION	İ		AGAINST DE	PARTMENT	/PROCESS	
WOIN OIG	···					Rework	1 	Skid-tube	Crosstube	1	Water Jet	Engineering
Part I	No.					Scrap		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
			-			Use-as-is	4 I	noforming	Finishing	4	re/Packaging	Other
NCR I	No					Work Order Update Large Fab Composite			Composite		Supplier	
Root					Descri	ption of work order update	Initial	Actio	on	Sign &		
Cause		ate	Step.	Qty		or Non-conformance	Chief Eng	Descrip	otion	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling			-							ļ		
Operator												
Material	Ш				1							
Setup												
Other												
Process												
Supplier												
Training												
Unapproved				<u></u>								
						F <i>i</i>	AULT CATE	GORY				
Landi	ng Gear					General				_	_	_
	Ben	ding				Bend	Grain			Ovalized		Pressure/Forced
	Cer	tre No	t Concer	ntric to	o/s	BOM/Route	Hardwa	re		Over/Under	tolerance	Temperature/Cure
•	Cra	cks				Broken/Damaged	Inspecti	on Incomplete		Part Incorre	ct	Weld
	Cru	shed/0	rimped.			Burrs	Instruct	ions Incomplete/Un	nclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuf	fs				Contamination	Mainte	nance		Part Moved		
	Hea	t Trea	t			Countersink	Mislabe	led		Positioned V	Vrong	_
	Insp	ection	Strip in	Tube		Cut Too Short	Misread	1		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

160

160

Packaging

Packaging

Memo

Receive & Inspect for Damage & Mat'l Certs

Ensure certificate of conformity is attached

Certificate of conformaty is required

0.00

0.00

											DQA:	Date:	•
NCR:	Yes	/ No				WORK ORDER NON-	CON	NFORI	MANCE / UP	DATE		_	
											QA Closed:	Date:	
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	•					Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality Other
NCR 1	No.					Work Order Update]	men	Large Fab	Composite	incer stor	Supplier	other
Root					Descri	ption of work order update	1	nitial	Act	tion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling		٠											
Operator									·				
Material													•
Setup 📆								* '				:	
Other 🤼	Ш	3											•
Process	Ш												
Supplier													
Training		i					1						
Unapproved							<u> </u>						
						F	AUL	T CATE	GORY				
Landi	ng G	Gear				General							
		Bending				Bend		Grain			Ovalized		Pressure/Forced
· '		Centre No	at Concer	ntric to 1	n/s [BOM/Route		Hardwa	re		Over/Linder	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Part Incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Weld

Other

Wrong Stock Pulled

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Work	Orde	r ID	93354
Novembe	r_10_12	8.58.0	14 AM

Work Order ID 93354 November-19-12 8:58:04 AM				Page :							
Item ID: Revision ID:	647.2511			Accept	*N900	040	100	* s	Setup Star	1 71	S1*
	Nut								Stop	*N	S2*
Start Date:	11/15/12	Start/Qty: 12.00	*12*		Cust Item I	D:					
Required Date:	12/07/12	Req'd Qty: 12.00	*12*		Customer:						
Reference:								Е	Run Star	t alan m	— 4 st
Approvals:	Process Pla	an:	Date:	Tooling:	Da	nte:		r		1/1	R1*
	QC:		Date:	SPC (Y/N):	Da	ate:			Stop	*N	R2*
Sequence ID/ Work Center II)	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170		QC5- Inspect part comple	eteness to step on W/O	0.00				13			
170		Memo		0.00 2. 13. 4	Q			<u> </u>			
Quality Control				12,4	7				<i>)</i>		
180		Identify as per dwg & Sto	ock Location: 53	0.00					4/3/4	./ .	(a)
180 Packaging Packaging		Memo		0.00					-/3/9	//0 (13)
			•								
190		QC21- Final Inspection -	Work Order Release	0.00					13/	4/10	0 00
190		M		0.00						1/	
Quality Control		Memo									

& Brooking

												DQA:	Da	ate:	٠.
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UP	DATE		·			
												QA Closed:	Da	ite:	
Work Orde	er.					DISPOSITION				AGAINST (DΕ	PARTMENT	PROCESS		
WOIK OIG	-				 	Rework]		Skid-tube	Crosstube		1	Water Jet		Engineering
Part 1	No.					Scrap	1		Machining	Small Fab		Pro	d. Eng. Coor.	-	Quality
	-					Use-as-is		Therm	noforming	Finishing		Rec/Stor	e/Packaging		Other
NCR I	۷o. ₋					Work Order Update]		Large Fab	Composite [Supplier		
Root				}	Descri	ption of work order update	Π	Initial	Ac	tion		Sign &		-	
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification	n	QC Inspector
Doc/Data	Ш														
Equip/Tooling															
Operator	Ш														
Material	Ш														
Setup	Ш														
Other	Ш														
Process															
Supplier															
Training															
Unapproved															
						F	AUL	T CATE	GORY						
Landi	ng G	ear			<u>, </u>	General				-		,			7
	Ш	Bending				Bend		Grain				Ovalized		L	Pressure/Forced
		Centre No	t Concer	ntric to (o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorred	ct		Weld
	Ш	Crushed/0	Crimped.			Burrs		Instruct	ions Incomplete/	Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			
		Heat Trea	t			Countersink		Mislabe	led			Positioned V	Vrong		_
		Inspection	Strip in	Tube		Cut Too Short		Misread		Ī		Power Loss/	Surge		Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

Picklist Print

November-19-12 8:58:04 AM

Work Order ID:

93354

Parent Item:

647.2511

Parent Item Name:

Nut

Start Date: 11/15/12

Required Date: 12/07/12

Page 1

Start Qty: 12.00

Required Qty: 12.00

Comments:

IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M174PH-H1150R1.000		Purchased	No				f	11.8000		0.6315789			40A
17-4 SS H1150 ROUND I	3AR 1.000			<u>Location</u>		Loc Qty	<u>Lo</u>	c Code		13.	3.	25	0,4
				MAT	450	11.8 11.8				8/3			

										DQA:	Date	·
NCR:	Yes / No)			WORK ORDER NON-O	COI	NFORM	MANCE / UPE	DATE			
	····	". .	_					· · · · · · · · · · · · · · · · · · ·		QA Closed:	Date	
Work Orde	ar.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	1 1 1 1				Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstub Machining Small Fa Thermoforming Finishir Large Fab Composit			-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update		Initial	Acti	ion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descri	iption	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling							,					
Operator		-				1						
Material												
Setup												
Other												
Process												
Supplier			į									
Training												
Unapproved										ļ <u></u>		
					F.	AUL	T CATE	GORY				
Landi	ng Gear			y	General	_				_		_
	Bendin	g			Bend		Grain			Ovalized		Pressure/Forced
	Centre	Not Conce	ntric to	o/s	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct _	Weld
	Crushe	d/Crimped			Burrs		Instruct	ions Incomplete/U	Inclear	Part Lost/M	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	nance		Part Moved	_	

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

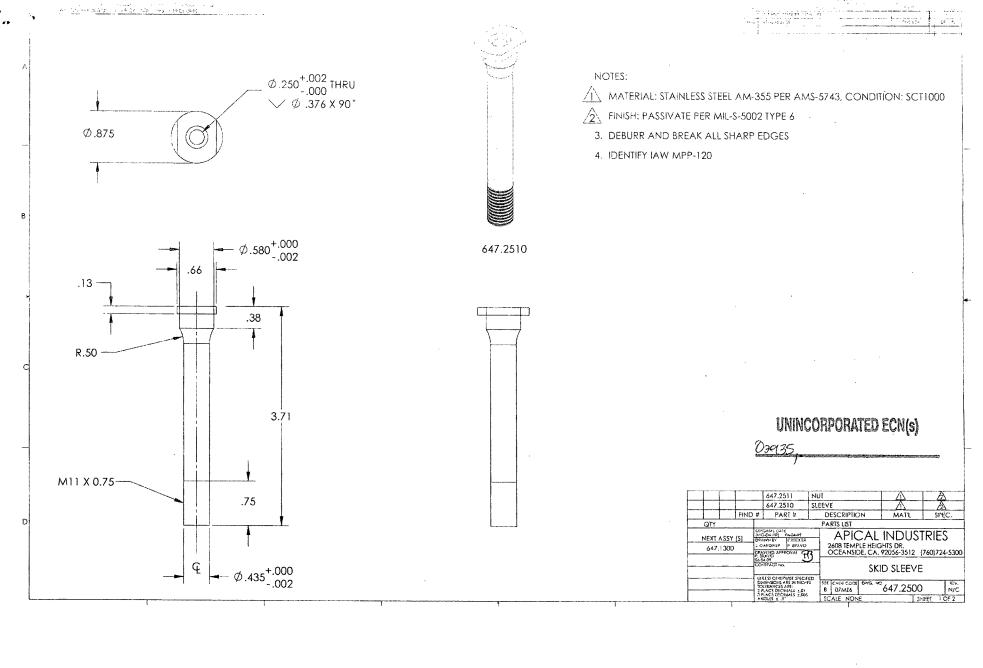
Drill Holes

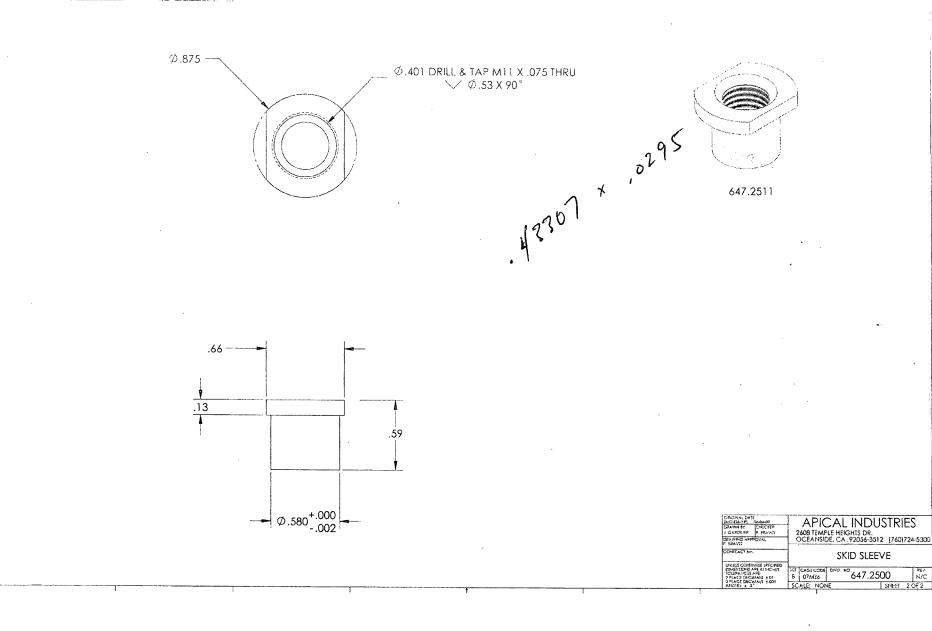
Drawing

Finish

Folio

APTCAL	ENGINEERING DWG NO. 647.2		TICL NO.	02935 ED. LCAR	DATE: 0	SHEET	EFFECT ON DWG
INDUSTRIES, INC.	The state of the s	KID SLEEV		N.CAP			INC. XI UNINC.
TRANSACTION CODES (TC): A-ADD C-CREATE R-REVISE D-DELETE	REASON: REVES	SED PART N	MATERIAL		o ossowy c y		
2 FINISH: 3. DEBURR	AL: STAINLESS STE PASSIVATE PER M AND BREAK ALL S Y IAW MPP-120	IL-S-5002 TY	<u> </u>	150		RLIU FNGIN UNCONTRO SUBJECT TO WITHOL WORK	AND DECIMENTS
F/N TC PART NUMBER	QTY	DESCRIP	· · · · · · · · · · · · · · · · · · ·		MATERIAL	SPEC	CIFICATION
DOCUMENTS EFFECTED:		INSTALL INSTR		CHANGE MAJE	CATEGURY DE	R REVIEW RE	QUIRED
17			2				





DART AEROSPACE LTD	Work Order: 9/437	
Description: 3417-5 WASHER	Part Number: 1) 34 (7 - 5	-
Inenection Dwg: Rev. C	Pose 4 of 4	4
Inspection Dwg: Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
875	+/008	. 874			2002	Vern
.40/9	7-90600/	. 404			11	
· 23 ×	1/0/9	- 537	_	<u>.</u>	ч	
90°	t/-, /2°	10°			• • •	
- 66	+/-,-010	,66/			į ¢	
. 13	4/0/0	.13/			I(
- 59	1/0/0	,89/		-	10	
. 580	+0002	1579			70.06	ımC.
	College Manager and the second					·
				1	to the state of th	
					1	

		· · · · · · · · · · · · · · · · · · ·				
	,				##### N. ## # # #	A CONTRACT OF THE CONTRACT OF

Meas	uréd by: ZA	Audited by:	Preliminary Approval:	
	Date: (7-7.29	Date: 13/03/29 9-89	Date:	

Rev	Date	Change		,	Revised by	Approved
E	10.04.14	Added preliminary a	pproval		KJ	



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62301

Date: 08-Apr-13

To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

	1 ax. 013-032-1165	Pfi. bis	3-032-5200	Fax: 613-632-1185	
Terms		Ship Via			
Quantity	Description				
1	Part: ASST		Rev:		
lot					
	13 PCS 647.2511 12 PCS 647.2510	į			•
	PASSIVATE PER QQ-P-35				
- 10 ANAMONTAL TRANSPORT	MINIMUM RUN	The state of the s	and the second s		ě
	Job: 20130198	PO: 19460	Line:		
	Certificate of Conformance				
	A.T.G. Industries certifies that all items in this shipment are in conformance				
	with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY				
	G/M/n	NIVIO AFFER			
	DATE: 0/7/13				
	CERTIFIED SIGNATURE :				
	RECEIVER SIGNATURE :				
	·				
		•			
		•			
	1.1				